

	ork Order ID 97696  bruary-21-13 12:40:43 PM  m ID: D3953-17			*976	396*						Page 1
Revision ID:	D3953-17 Gas Spring		4	Accept	*N900	<u>040</u>	100	* s	etup Star Stop	1 13	S1* S2*
	3/11/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item   Customer:	ID:					. 17
Approvals:		Plan: MUS	,			ate:		H	Run Star Stop	, "I <b>V</b> I	R1* R2*
Sequence ID/ Work Center II		Operation : Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	I	Revision Nbr									
D3953		<u> </u>			·						
*100  *100* Waterjet FLOW CNC Waterj	jet	<b>Memo</b> 1-Cut as per	Dwg D3953	0.00				20	0		JmB-3-17
304,375	x3"	Dwg Rev: Prog Rev:							-		
		2- OPEN HO	DLES AS PER DWG								
		3- DEBURR	IF NECESSARY								
110 *4.4.0*		QC2- Inspect parts off m	achine FAI/FAIB	0.00				۵	·_		* > > > 1
*110* QC Quality Control		Мето		0.00				30			Jm13-3-17

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No NCR: QA Closed: Date: **DISPOSITION** AGAINST DEPARTMENT/PROCESS Work Order: Water Jet Engineering Rework Skid-tube Crosstube Quality Machining Small Fab Prod. Eng. Coor. Part No. Scrap Rec/Store/Packaging Other Use-as-is Thermoforming Finishing NCR No. Large Fab Composite Supplier Work Order Update Description of work order update Initial Action Sign & Root or Non-conformance Chief Eng Description Date Verification QC Inspector Qty Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other

FAULT CATEGORY									
Landing (	Gear	General				_			
	Bending	Bend		Grain		Ovalized	Pressure/Forced		
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure		
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld		
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled		
	Cuffs	Contamination		Maintenance		Part Moved			
	Heat Treat	Countersink		Mislabeled		Positioned Wrong			
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other		
	Ripples in Bend	Drill Holes		Offset					
	Torque Waves in Extrusion	Drawing		Out of Calibration					
	Turning Sequence	Finish		Out of Sequence					
	Wave/Twist in Tube	Folio		Outside Dimensions					

Process
Supplier
Training
Unapproved

Work Ord February-21-13				*97	696*	-				Page 2		
Item ID: Revision ID: Item Name:	D3953-17 Gas Spring S	pacer		Accept	*N900	<b>040</b>	100*	Se	tup S	Start Stop	*N:	S1* S2*
Start Date: Required Date Reference:	3/11/13 :: 3/11/13	Start Qty: 20.00 Req'd Qty: 20.00		70* 70*	Cust Item I Customer:	D:						
Approvals:		an:				ate:		Ru		Start		R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	ID	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00  OAS 0.00 16 0.00	Tool ID	Tool#	Code (	eccept Oty	Rejec Qty		Reject Number	Insp. Stamp
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ck Location:	61 61 60.00 0.00			, -(	)OX				SP 3-3-1
140 <b>*140*</b> QC Quality Control		QC21- Final Inspection -  Memo	Work Order R	elease 0.00 0.00						13	3/3/	2020

UB-03-16

											DQA:	Date	:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	<b>VFORN</b>	MANCE / UPDAT	Έ	•			
								,			QA Closed:	Date	:	
Work Orde	<b></b>					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Work Orde	er					Rework	1		Skid-tube Cr	rosstube		Water Jet	Engineering	
Part N	No.					Scrap	1	Machining Small Fab			Proc	d. Eng. Coor.	Quality	
	-	· · · · · · · · · · · · · · · · · · ·				Use-as-is	Therm	oforming F	Finishing	Rec/Stor	e/Packaging	Other		
NCR No.				Work Order Update	]		Large Fab Co	mposite		Supplier				
Root	Ĭ				Descri	ption of work order update	Ī	Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descriptio	on	Date	Verification	QC Inspector	
Doc/Data	Ш													
Equip/Tooling	Ш							į						
Operator														
Material														
Setup													İ	
Other														
Process	Ш			•										
Supplier														
Training				]										
Unapproved														
						F	AUI	LT CATE	GORY					
Landi	ng G	iear				General		_				_	_	
		Bending				Bend		Grain			Ovalized	L	Pressure/Forced	
		Centre No	ot Concer	ntric to O	)/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Uncle	ear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong _		
	П	Inspectio	n Strip in	Tube		Cut Too Short		Misread	ł		Power Loss/	'Surge	Other	
	П	Ripples in Bend				Drill Holes		Offset						

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

# **Picklist Print**

February-21-13 12:40:43 PM

Work Order ID:

97696

Parent Item:

D3953-17

Parent Item Name:

Gas Spring Spacer

**Start Date: 3/11/13** 

Required Date: 3/11/13

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP RevA: New issue DD verified by:EC

verified by:EC

IPP Rev:B as per dwg revC DD 10.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M304B0.375X03.000		Purchased	No			100	f	8.9280	0.03125	.0.657894		- Ti. 2 2 17
M304 SS bar .375 x 3.00										1.0		JM12,2114

 Location
 Loc Oty
 Loc Code

 MAT051
 8.928
 I20204

								•				DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	O	NFORN	ANCE / UP	DATE				_	
						<del> </del>						QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION		AGAINST DEPARTMENT/PROCI					PROCESS		
WOIK OIU	٠	<del></del>				Rework	1		Skid-tube	Crosstube		Water Jet			Engineering
Part I	No.					Scrap	1 1		Machining	Small Fab	$\exists$	Prod. Eng. Coor.			Quality
					<del>-</del>	Use-as-is Therr			noforming	Finishing	╗		e/Packaging	-	Other
NCR	No.					Work Order Update	]		Large Fab	Composite			Supplier		
-															
Root			:			ption of work order update	}	nitial		tion		Sign &			•
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling												·			
Operator			1												
Material										•					
Setup	Ш										,				
Other					•		ł					· ·			
Process				•			ļ						,		
Supplier						•	İ								
Training					-										
Unapproved	L			<u> </u>											
							AUL	T CATE	GORY						
Landi	_				_	General		1		г		1			1_
	$\vdash$	Bending			\	Bend	-	Grain		.		Ovalized		$\vdash$	Pressure/Forced
	$\vdash$	Centre No	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa		-		Over/Under		-	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	$\vdash$	4	ion Incomplete			Part Incorre		<u> </u>	Weld
		Crushed/	Crimped.		<u> </u>	Burrs	$\vdash$	4	ions Incomplete/	'Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination	$\vdash$	Mainte		].		Part Moved			
	$\vdash$	Heat Trea			<u> </u>	Countersink	<u>_</u>	Mislabe		<u> </u>		Positioned V		_	7
		Inspection	spection Strip in Tube Cut Too Short					Misread	t			Power Loss/	Surge	1	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	97696
Description: Gas Spring Spacer	Part Number:	D3953-17
Inspection Dwg: D3953 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

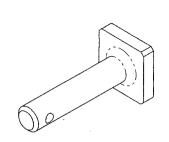
X First Article Prototype

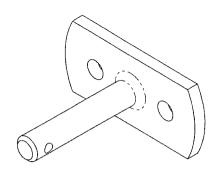
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.195"	_		V	JAMOI
0.375	+/-0.010	0.368	U		V	
0.625	+/-0.010	0.627"	_		V	
138	+/-0.030	1.374"			V	
0.38	+/-0.030	0.374"			V	
0.75	+/-0.030	0.756"	_		V	
0.38	+/-0.030	0.372°	<u>ب</u>		V	
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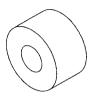
Measured by:	Jm	Audited by: \( \frac{\frac{1}{4}}{4} \)		Prototype Approval:	N/A
Date:	13-3-17	Date: 9	6ª 17/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.10.22	New Issue	KJ 44	
В	09.12.14	Dwg Rev updated	KJ 👭	M

0









D3953-1 GAS SPRING BRACKET (FULL LID)

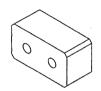
**D3953-3 GAS SPRING STUD, LID** 

D3953-5 GAS SPRING STUD, BASE

**D3953-7 GAS SPRING SPACER** 

**D3953-9 GAS SPRING WASHER** 











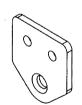
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER (FULL LID)

D3953-15 GAS SPRING BRACKET (SPLIT LID)

**D3953-17 GAS SPRING SPACER** (SPLIT LID)

D3953-19 GAS SPRING BRACKET



D3953-21 GAS SPRING BRACKET (SQUARE BASKET)

<u></u>

PARTS -19 & -21 ADDED (SHT 1& 4): CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4): © SYMM WAS © SYM ABOUT (C7-2, C7-4): SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS JPH 10.01.29 SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TO LERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY. AJS 09.11.11 A NEW ISSUE AJS 09.07.27 REV. DESCRIPTION BY DATE

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3953 MFG, APPR. SHEET 1 OF 4 TITLE APPROVED GAS SPRING LID COMPONENTS NTS

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THIS DOCUMENT IN ARRIVE AND CONTRIBUTION, AND IN HIS CONTRIBUTION, AND IN HIS CONTRIBUTION, AND IN HIS CONTRIBUTION AND IN HIS CONTRIBUTION AND IN HIS CONTRIBUTION AND IN HIS CONTRIBUTION AND IN HIS CONTRIBUTION AND IN HIS CONTRIBUTION OF MARKET AND AND IN HIS CONTRIBUTION OF MARKET AND IN HIS CONTRIBUTION O DE APPR. DATE 10.01.29

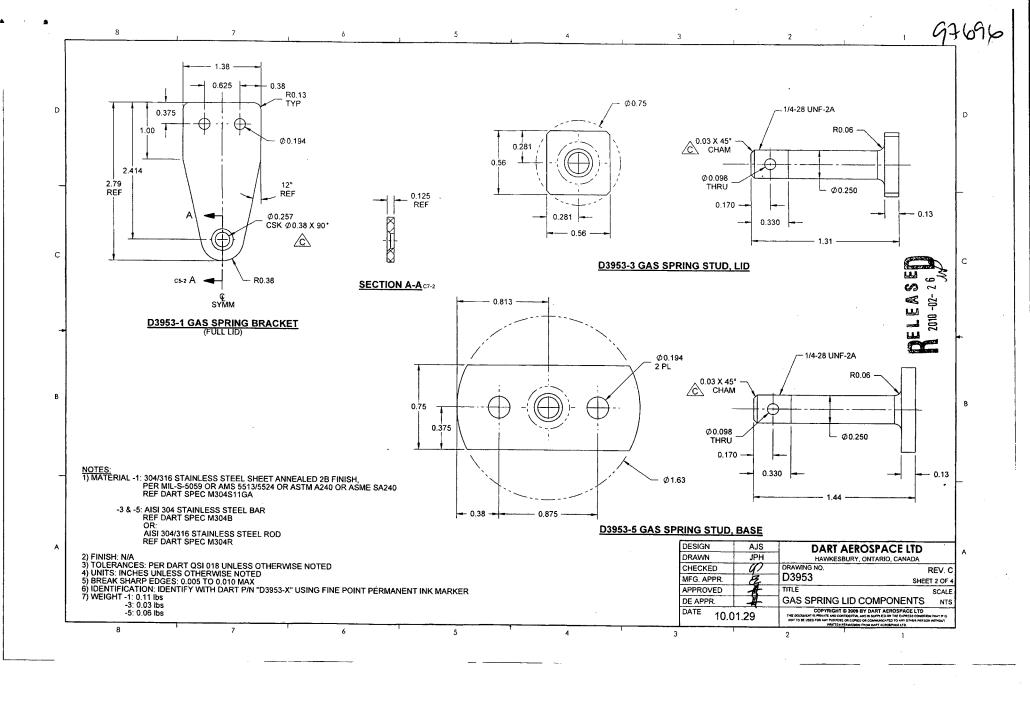
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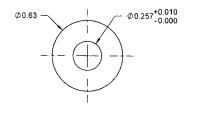
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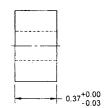
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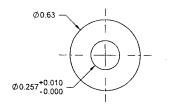


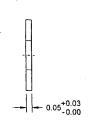
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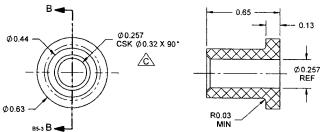


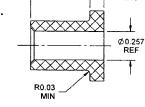




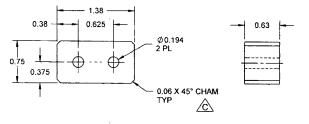


### **D3953-7 GAS SPRING SPACER**





SECTION B-B 87-3



## **D3953-13 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER** 

NOTES: 1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLA	СК
REF DART SPEC M-DELRIN-R	

**D3953-11 GAS SPRING SPACER** 

-13: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B

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D

С

- 2) FINISH: N/A
  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13"
  7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
  -13: 0.17 lbs

N'	'D3953-13"	USING FINE POIN	T PERMANENT	INK MARKER	

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED	a	DRAWING NO. REV. C
MFG. APPR.	8	D3953 SHEET 3 OF
APPROVED	-	TITLE SCALE
DE APPR.	#	GAS SPRING LID COMPONENTS NTS
DATE 10.01.29		COPYRIGHT © 2009 BY DART AEROSPACE LTD THE GOCUMENT IS MINATE AND COMPRESENT AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

